

Work Order ID 131214

March-30-15 1:50:21 PM

131214

May 5
2 - stock
1 - 5/0

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Item ID: D117-840-011 Accept *N9000040100* Setup Start *NS1*
 Revision ID:
 Item Name: Bearpaw with Wearplates Stop *NS2*
 Start Date: 3/30/15 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 3/30/15 Req'd Qty: 3.00 *3* Customer:
 Reference: ECN15-535

Approvals: Process Plan: u Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D117-840	B

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-840-011		CHG 002						

APR 23 2015

MLJ 15-04-01
3

160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							

DAS
66
9-89

Packaging
 PULL FROM STK:
 3 X D117-840-011 B129609
 REMOVE FROM EACH KIT:
 4 X D4012-1 REV.B
 4 X D4799-1 REV.B
 SCRAP/DESTROY PARTS
 ADD TO EACH KIT:
 4 X D4012-1 REV.C
 4 X D4799-1 REV.C

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Item ID: D117-840-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw with Wearplates
 Start Date: 3/30/15 Start Qty: 3.00 ***3*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00	DAS 46						
Quality Control									

180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N NEW LABELS REQ'D								

****NEW PAPERWORK ALSO REQUIRED****

Identify and pack for shipping as per PPP D117-840-011

Location: 05

PPP Rev: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCS 1504-24
ME 15-4-24

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Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 3/30/15**Required Date:** 3/30/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP
REV:B 13.05.28 PER IIN D117-840 REV.A DD VERF:JLM IPP REV:C
15.03.30 PER REV B JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D117-840-011		Manufactured	No				Each	0.0000		3			
D117-840-011 Bearpaw with Wearplates													
D4012-1		Manufactured	No				Each	29.0000		12			
D4012-1 Cushion													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FG			4						
				97172			4						
				ST545			25						
				119517			2						
				129617			22						
				129619			1						
MUST BE REV.C													
D4799-1		Manufactured	No				Each	29.0000		12			
D4799-1 Clamp													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st543			29						
				129612			29						

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011 <i>Bearpaw Installation</i>	27.7 lb 12.6 kg	0.0 in 0.0 mm	0.0 lb-in 0.0 mm-kg	204.1 in 5200 mm	5653 in-lb 65,520 mm-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
12	D3456-1	WASHER
4	D4012-1	CLAMP CUSHION
2	D4796-1	BEARPAW
2	D4798-041	WEARPLATE ASSY
4	D4799-1	CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
8	NAS1149D0463J	WASHER